

# Work Order ID 54865

January 4, 2010 10:43:24 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket End)

Stop



Start Date: 05/01/2010 Start Qty: 6.00

Required Date: 11/01/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date:

*10-1-04*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3825

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

*SAI 10-01-27*

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 PD  
A/R S.S. Rod Batch: *4109213*

7- grind bushing weld flush where indicated on dwg D3825 PD

8- deburr if necessary PD

*PD 10.01.29 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PL 10/02/01

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

→ S 10/02/01

(26)

150

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

PD 10.02.01 (2)

W/O:		WORK ORDER CHANGES					
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Start Date: 05/01/2010 Start Qty: 6.00



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Required Date: 11/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/02

MF

10-2-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

January 4, 2010 10:43:29 AM

Page 1

Work Order ID: 54865

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 05/01/2010

Required Date: 11/01/2010

Comments: IPP RevA: revise process 09.11.11 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

33.0000

6.0000



Spacer Bushing

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

33

44274

4

44365

9

54135

20

PD 10.01.29

D3759-1

Manufactured

No

100

Each

42.0000

6.0000



Bushing

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

WA

42

53442

6

54072

36

PD 10.01.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January 4, 2010 10:43:29 AM

Work Order ID: 54865



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 05/01/2010

Required Date: 11/01/2010

Comments: IPP RevA: revise process 09.11.11 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

314.4400

13.4211



304 SQ Tube .75x.75x.065W



SAD 10-01-27

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

314.4399742

113082

0.00419

113245

314.435784

Main Warehouse

WA

0.0000047

112398

0.0000047

13.4211

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

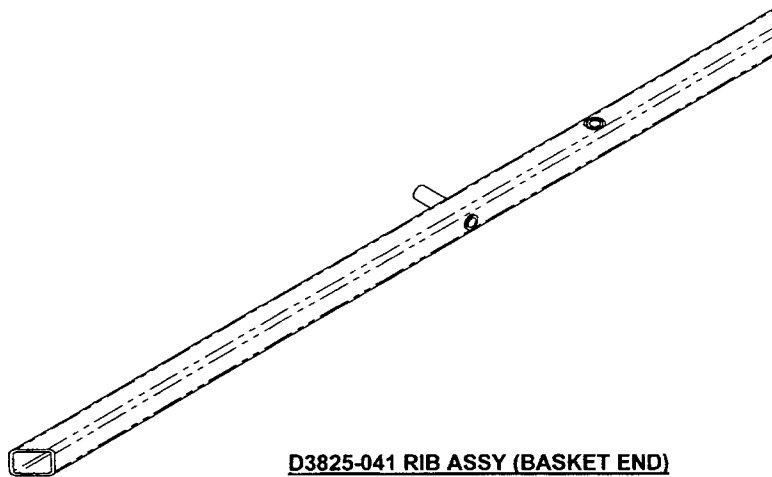
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54865  
BT 10-1-04

**RELEASED**  
08/11/18

NOTES:  
MATERIAL: N/A  
FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: 1.22 lbs  
WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3825</b>	REV. A
TITLE <b>RIB ASSY (BASKET END)</b>	SCALE NTS
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8 7 6 5 4 3 2 1

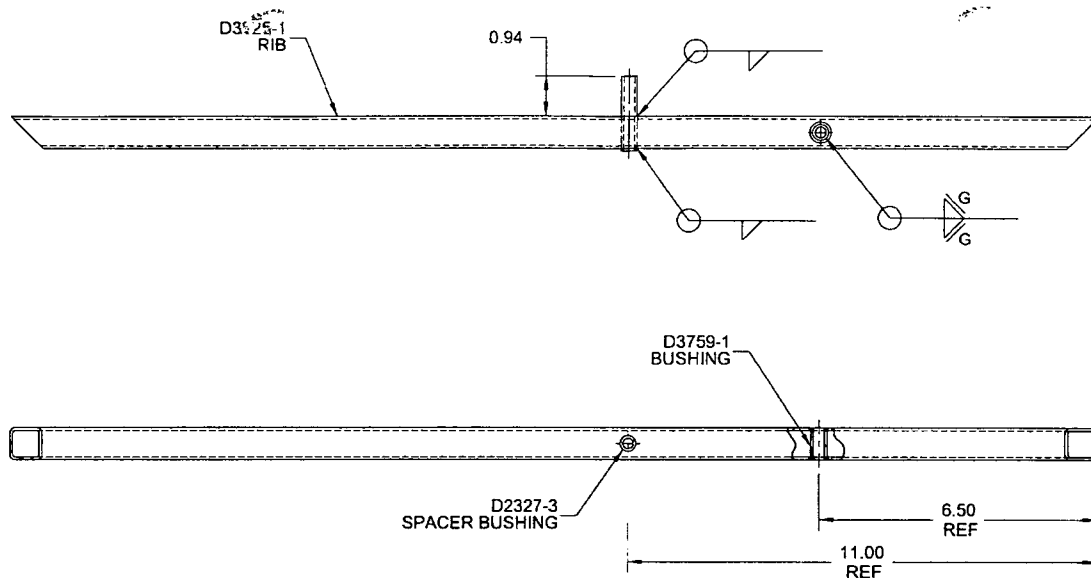
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3825-041 RIB ASSY (BASKET END)**

**RELEASED**  
08/11/18

W1054865

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. <b>D3825</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET END)</b>	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

A

$\varnothing 0.375^{+0.020}_{-0.000}$  THRU  
 $\varnothing 0.49 \times 100^\circ$  CSINK  
 ON BOTH SIDES

6.500

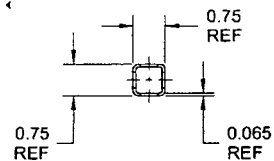
0.375

$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

0.375

11.000

25.50

**D3825-1 RIB**

**RELEASED**  
 08/11/18

W10 54845

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:  
 MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 IDENTIFICATION: N/A  
 WEIGHT: 1.18 lbs

8

7

6

5

4

3

2

1

W/O:		WORK ORDER CHANGES					
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